

ship Dec 9.

Work Order ID 152722

Monday, November 07, 2016 9:27:51 AM

152722

Page 1

Item ID: D4880-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B FWD Leg Assembly, RH
 Start Date: 11/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: NOV 07 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4880	C								
110		0.00							
110									
Small Fab	Memo	0.17							
Small Fab	ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 AND D4884-1. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9972 AS PER DWG.								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

1 Pick kit

NOV 15 2016

DAS 6 9-89

1 FF

NOV 16 2016

DAS 38 9-89

NOV 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Work Order ID 152722

Monday, November 07, 2016 9:27:52 AM

152722

Page 3

Item ID: D4880-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206A/B FWD Leg Assembly, RH
Start Date: 11/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location SH-30A	0.00							
180									
Packaging	Memo	0.00							
Packaging									

DAS
38
9-89

NOV 26 2016

DAS
6
9-89

NOV 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89 NOV 24 2016

DAS
21
9-89 NOV 24 2016

DQA: _____ Date: _____



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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																														

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152722

D4880-042

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12 *HI 32PB5-12* Hi-Lok Pin		Purchased	No				Each	51.0000		4			
									**			NOV 1 5 2016	DAS 6 9-8
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST562				51					
					M129912			51					
D4880-1 *D4880-1* Strut		Manufactured	No				Each	9.0000		1			
									**			NOV 1 5 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA ST 133				9					
					152535			9					
D4883-5 *D4883-5* End Fitting		Manufactured	No				Each	5.0000		1			
									**			NOV 1 5 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				5					
					152487			5					
D4884-1 *D4884-1* End Fitting, Eye		Manufactured	No				Each	0.0000		1			
									**			NOV 1 5 2016	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				5					
					152487			5					

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, November 07, 2016 9:27:51 AM

Page 2

Work Order ID: 152722

152722

Parent Item: D4880-042

D4880-042

Parent Item Name: 206A/B FWD Leg Assembly, RH

Start Date: 11/7/2016

Required Date: 11/15/2016

Start Qty: 1.00

Required Qty: 1.00

HL86-5

Purchased

No

Each

472.0000

4

HI 86-5

DAS

Hi-Lok Collar

6

9-89

NOV 15 2016

Location

Loc Qty

Loc Code

ST562

472

M129022

200

M129864

272

DQA: _____ Date: _____



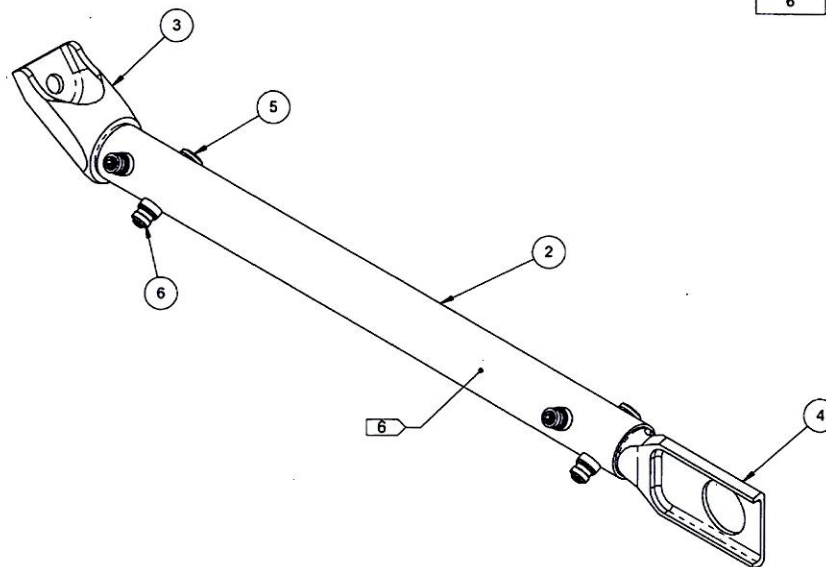
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4880-042	FWD LEG ASSEMBLY, RH
2	1	D4880-1	STRUT
3	1	D4883-5	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 152722 MJS

16-11-07

D4880-042 FWD LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-101-102)

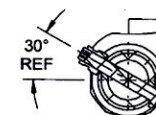
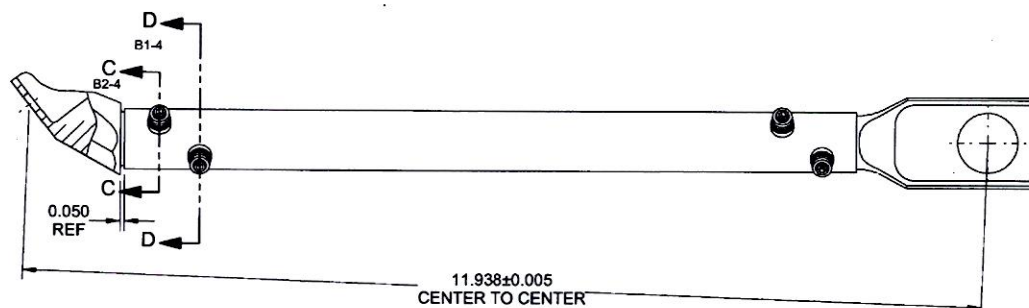
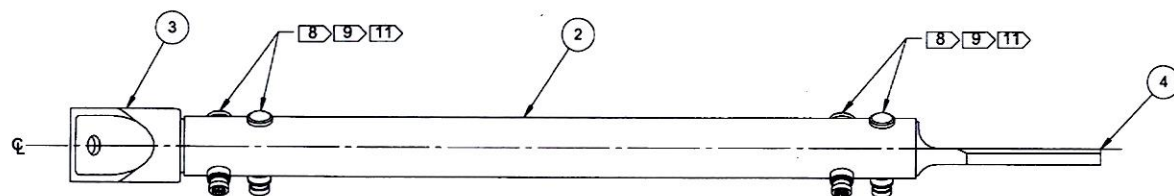
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9972
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9972
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

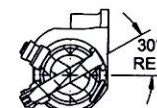
RELEASED
2014-07-07

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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SECTION C-C C7-4
2 PL



SECTION D-D C7-4
2 PL

D4880-042 FWD LEG ASSEMBLY, RH
AUXILIARY VIEW

RELEASED
2014-07-07

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO. D4880	REV. C
MFG. APPR.	JLM		SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34375**

Purchase Order Date 11/18/2016

PO Print Date 11/18/2016

Page Number 1 of 2

Order From :
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
NOV 18 2016

Contact Name
Vendor Phone 613-931-1241

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	153106	D4880-041 LEG ASSEMBLY	11/23/2016 Yes 11/23/2016		2.00	\$4.00	\$8.00
	ENGRAVE PART # D4880-041						
						Line Total:	\$8.00
2	152722	D4880-042 LEG ASSEMBLY	11/23/2016 Yes 11/23/2016		1.00	\$4.00	\$4.00
	ENGRAVE PART # D4880-042						
						Line Total:	\$4.00
3	153091	D4880-042 LEG ASSEMBLY	11/23/2016 Yes 11/23/2016		2.00	\$4.00	\$8.00
	ENGRAVE PART # D4880-042						

Note:

11/18/2016



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

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DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE November 21, 2016

P.O NUMBER PO34375

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-041 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4880-042 LEG ASSEMBLY ✓	1	
D4880-042 LEG ASSEMBLY	2	
D4882-041 LEG ASSEMBLY	2	

SP 1611-24

DAS
38
9-89



19226 Airport Road
Summerstown, ON
K0C 2E0
plprinting@bellnet.ca

Tel.: 613 931-1241
Fax: 613 931-2560
www.plprinting.ca

Invoice

Number: 8791

Date: November 21, 2016

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
34375		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4880-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4880-042 ✓	1.00	4.00	✓	4.00
Laser Metal Marking, D4880-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4882-041	2.00	4.00	✓	8.00
<i>SP 10-11-24</i>				

DAS
38
9-89

Sub-Total	\$28.00
13.00% on 28.00	3.64
Total	\$31.64

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